

Work Order ID 52754

October 14, 2009 9:04:53 AM



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Item ID: D350-607-143

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Installation

Start Date: 14/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 26/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: PL Date: 09-10-14 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9473	A								

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-607-143 / DSI9473
CHG001

HJ for BG 09/11/11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/11/11 20 SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

CHG/88 09/11/11

2

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Item ID: D350-607-143

Accept



Setup Start



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Item Name: Gas Spring Installation

Start Date: 14/10/2009 Start Qty: 2.00



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Required Date: 26/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D350-607-143 / DSI 9473								
	Location: _____								
	PPP rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

2/11/12 (27) 21

09/11/13 HJ

MF
09-11-13

Picklist Print

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Work Order ID: 52754

Parent Item: D350-607-143

Parent Item Name: Gas Spring Installation








Comments:

Start Date: 14/10/2009

Required Date: 26/10/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-3 		Manufactured	No			110	Each	0.0000	2.0000			sl
Gas Spring Stud, Lid D3953-5 		Manufactured	No			110	Each	0.0000	4.0000			sl
Gas Spring Stud, Base D3953-9 		Manufactured	No	B53612	9/11/12	110	Each	0.0000	4.0000			sl
Gas Spring Washer D3953-11 		Manufactured	No			110	Each	0.0000	2.0000			sl
Gas Spring Spacer D3953-15 		Manufactured	No			110	Each	0.0000	2.0000			sl
Gas Spring Bracket D3953-17 		Manufactured	No			110	Each	0.0000	2.0000			sl
Gas Spring Spacer D3969-1 		Manufactured	No			110	Each	0.0000	2.0000			sl
Gas Spring (Basket Lid) AN3C11A 		Purchased	No			110	Each	50.0000	4.0000			sl
BOLT												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

112255

50

B52757 sl

B53434 sl

~~B52759~~ sl

B52767 sl

B52762 sl

B52763 sl

52889 sl

M112255 sl

9/11/11 (2x)

Picklist Print

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Work Order ID: 52754



Parent Item: D350-607-143



Parent Item Name: Gas Spring Installation

Start Date: 14/10/2009

Required Date: 26/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C15A 	SB	Purchased	No			110	Each	50.0000	4.0000		9/11/11	SP
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

112255

50

AN310-4

SB

Purchased

No

110

Each

36.0000

4.0000

4x 50

9/11/11

(2x) SP

NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

110098

36

①
M110098
M112969 (3x)

Picklist Print

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Work Order ID: 52754

Parent Item: D350-607-143

Parent Item Name: Gas Spring Installation


Start Date: 14/10/2009

Required Date: 26/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3  Nut		Purchased	No			110	Each	5,135.000	8.0000 4x		9/11/11	SP

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 80

103691 80


Main Warehouse

ST 5055

111819 78

112243 39

112314 4938



MS24665-2-12  COTTER PIN		Purchased	No			110	Each	194.0000	4.0000 2x		9/11/11	SP
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Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 194

111499 194

NAS1149C0332-AN960C10C  Washer		Purchased	No			110	Each	0.0000	8.0000 4x		11/21/16	SP
NAS1149C0432H-AN960C416L  Washer		Purchased	No			110	Each	0.0000	4.0000 2x		9/11/11	2x

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Shop Packet Print

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DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/045/047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	GAS SPRING KIT INSTALLATION (FOR USE ON -041 BASKET*)
2		X		D350-607-143	GAS SPRING KIT INSTALLATION (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	GAS SPRING KIT INSTALLATION (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3 20	GAS SPRING STUD (LID)
6	2	2	1	D3953-5 20	GAS SPRING STUD (BASE) Make 5/24 3/4 x 10 wip
7	2		1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9 40	GAS SPRING WASHER
9	2	1	1	D3953-11 40	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15 4	GAS SPRING BRACKET make
12		1		D3953-17 14	GAS SPRING SPACER
13	2	1		D3969-1 wip	GAS SPRING
14	4	2		AN3C11A	BOLT
15				AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2		AN310-4	CASTELLATED NUT
20	8	4		MS21043-3	NUT
21	4	2		MS24665-212	COTTER PIN
22	8	4		NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2		NAS1149C0432R	WASHER (OR AN960C416L)

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE GAS SPRING KIT PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-041A
D350-607-043 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-043A
D350-607-045 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-045A
D350-607-047 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-047A

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)
DATE: 09.11.04
CERT. NO.: SH94-14
ISSUE NO.: 4

B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR)	AJS	09.11.
A	NEW ISSUE	AJS	09.09.
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV
MFG. APPR.	N/A	DSI 9473	SHEET 1
APPROVED		TITLE	SC
DE APPR.		GAS SPRING UPGRADE KIT	
DATE	09.11.04	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	